



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBT18554
Job Sheet 188713



Part No: RBT18554

Job Qty: 4 pcs

Part Name: Main Rotor Hub Alignment Work Aid



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/14/19

Job Tracking No:

Due Date: 2/14/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG RBT18554 Rev.A IPP Rev. A 18.12.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	NLX 2500SY - 1	4 pcs	2/14/19	2/14/19	0.00	4.00	SL2500SY - 1		
110	QC 2	4 pcs	2/14/19	2/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
120	QC 8	4 pcs	2/14/19	2/14/19	0.00	0.00	QC 8 - 12		



Container No: S152216



Part: RBT18554

Job No: 188713

Serial No/Batch: S152216

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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www.dartaerospace.com

Date: 02/10/19

				QC 8 - 14	Plex 1/14/19 2:16 PM dart.lacelle.linda
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
130	Packaging 3-1 - Stock - B4B	4 pcs	2/14/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
140	QC 21 - FG	4 pcs	2/14/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
Part Op 100 - 1-Machine as per folio FC <u>599</u> . FOLIO REV: _____ DWG REV: _____ 2-Debur Descriptions: 120 - No surface finish required as per engineering. 130 - <u>ENGRAVE PW RISTIEG44</u>					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6R2.500	6061-T6 Round Bar 2.500"	2.6640 ft (.666 ea)	100-NLX 2500SY - 1		
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-NLX 2500SY - 1	M6061T6R2.500	3	0	0	
Part Specifications					
Specifications could not be found. <u>Due on 30 JAN</u>					

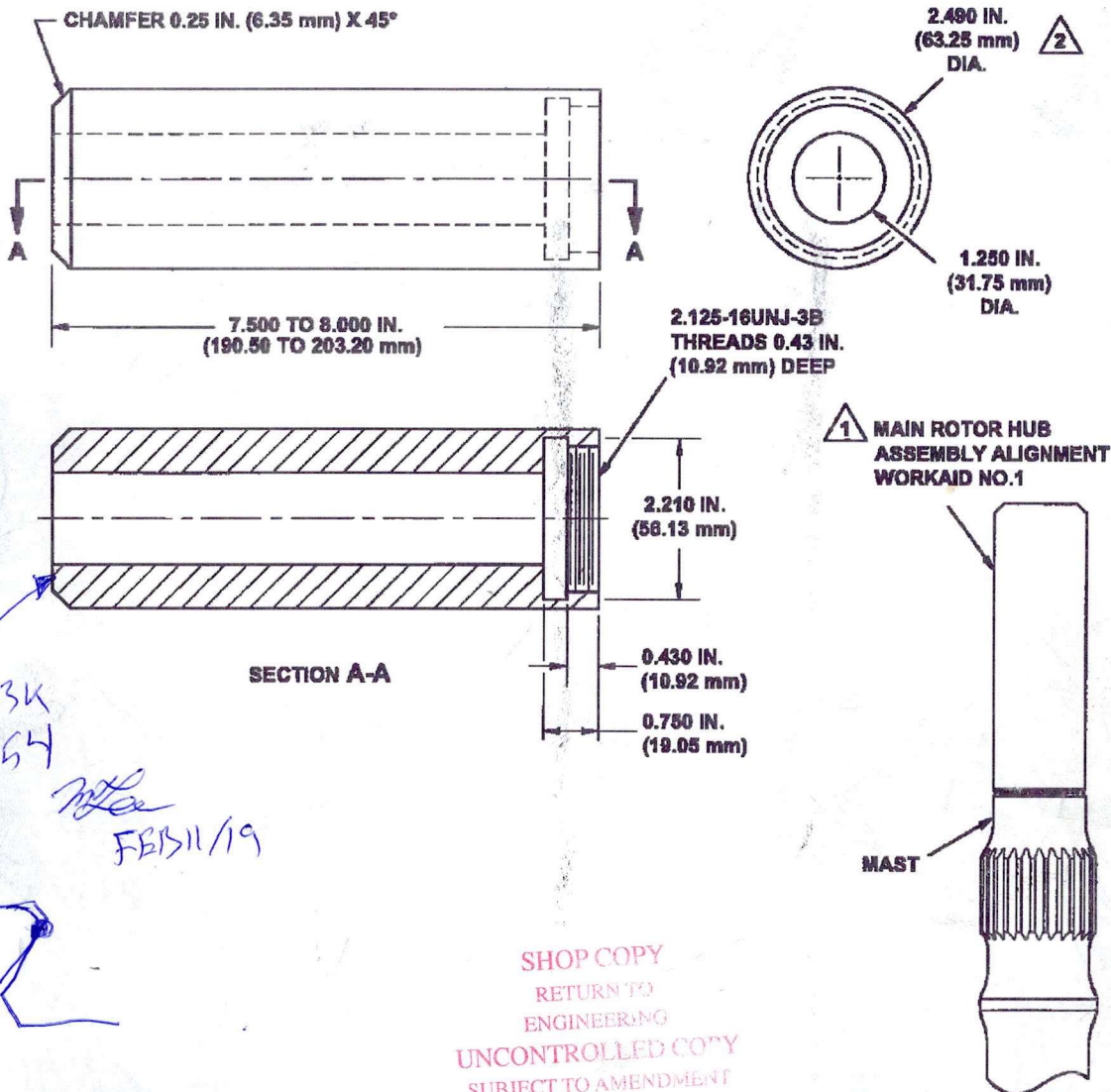
DAS
28
21
9-89
FEB 12 2019

GA
sed

USE UN TAP BUT INCREASE
MINOR DIAMETER

2:0625

~~1.177~~ ? ~~2.1094~~
~~2.125 (1.125 x 0.0025 x cos 30) =~~



MATERIAL: ALUMINUM 6061-T6

NOTES

- 2 Inside diameter to outside diameter concentricity to be within 0.002 inch (0.05 mm).
3. All dimension tolerances are ± 0.010 inch (0.25 mm).

Main Rotor Hub Assembly — Alignment Workaid

RBT18554 Rev. A

PEC 13/2018
ECN 18-862

7.617

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RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
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WORK ORDER
NO. 188713 MJS
1901-15